

Work Order ID 76092

76092

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November-07-11 7:56:02 AM

Item ID: D2279 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 07/11/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/07 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2279	Rev D								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00 20 0 Jm 12-6-14
 FLOW CNC Waterjet 1-Cut as per Dwg D 2279 Dwg Rev: D Prog Rev: D 2-
2004.040 Deburr if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 20 0 Jm 12-6-14
 Quality Control

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00 counts
Scrubbed fzo
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form As per Dwg D2279								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten notes and stamps:
 12/06/19
 8/10/21
 20
 20
 20
 12-6-25

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				20X			12/07/11
Quality Control									
170	Identify as per dwg & Stock Location: 6A	0.00							
170									
Packaging	Memo	0.00				20X			12/07/11
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00				CK			12/7/12
Quality Control									

12/20/11

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Picklist Print

November-07-11 7:56:06 AM

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Work Order ID: 76092

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Parent Item: D2279

D2279

Parent Item Name: Step Spacer

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev: A New Issue 05-11-07 JLM

IPP Rev: B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

76.8184

0.147

3.094737

M2024T3S 040

**

Jm 12-6-14

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

76.818421

117684

76.818421

120605

120605.

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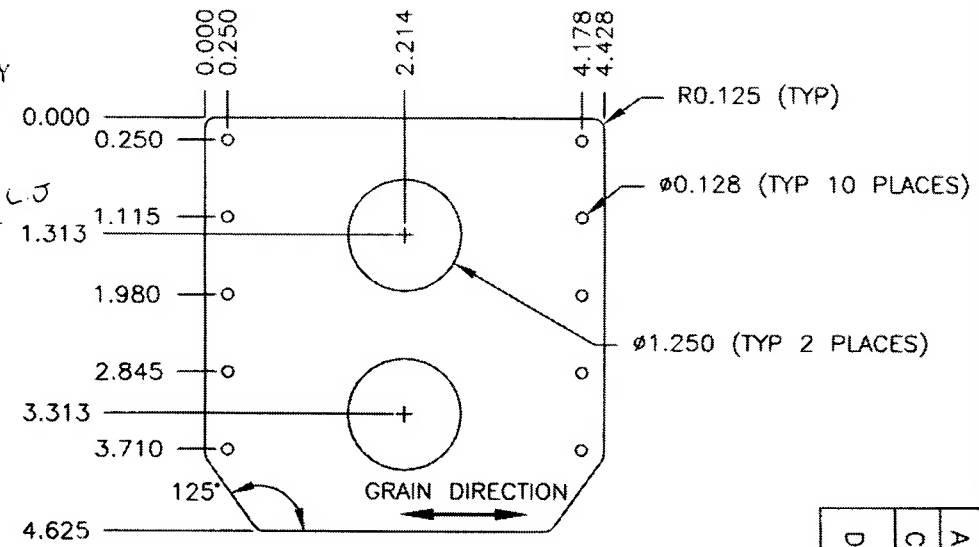
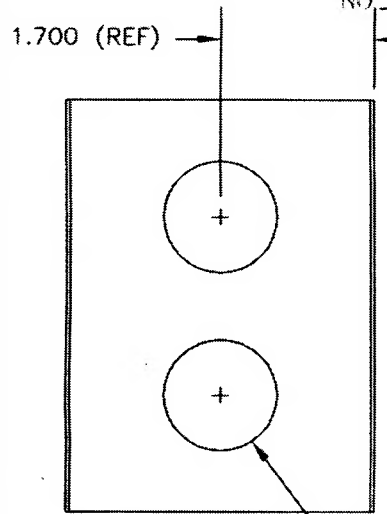
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	JP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	JP	D2279
DATE	TITLE	SHEET 1 OF 1
98.10.05	STEP SPACER	SCALE 1:2
A	94.10.13	NEW ISSUE
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912

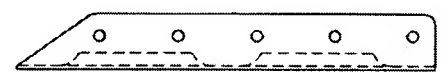
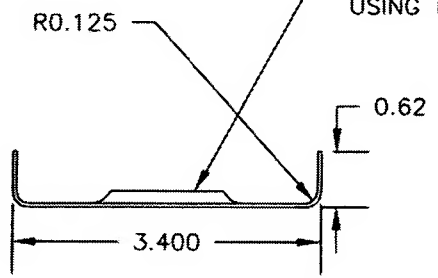
SUBJECT TO
REFERENCE
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 76092 M.C.S
11/11/07



FLAT LAYOUT

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



UNDER REVIEW
DESIGN OK, BUT CHECK WITH
TS BEFORE MANUFACTURE
OK 07/04/09

RELEASED
98.10.08 DS

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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